

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010621**Date Inspected:** 17-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Gong Liang Zhu, Chen Ying Xin.			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10, North Tower, Lift 2.

Installing Interior Splice Plate on Skin A.

Bay 10, South Tower, Corner Splice Sub Assembly Plate.

FCAW welding of weld joint SSD1-SPSA4-16-1A & SSD1-SPSA4-24-3B; located on Bay 10, South tower. Welders are identified as 040261, 066155; ZPMC Quality Control Inspector (QC) is identified as Gong Liang Zhu. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-B-T-2232-B-U5-F, 2) WPS-B-T-2231-TC-U5-F.

Bay 11, East Tower, Interior Splice Plate.

FCAW welding of weld joint ESD1-SPSA4-5-2A; located on Bay 11, East tower. Welders are identified as 202821; ZPMC Quality Control Inspector (QC) is identified as Zhan Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Bay 10, North Tower, Strut Angle Splice.

SMAW Repair welding of weld joint ND1-A5012-20-1A/B(CWR # T-CWR422); located on Bay 10, North

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tower. Welders are identified as 050289; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:
1) WPS-485-SMAW-1G(1F)-FCM-REPAIR-1.

This QA Inspector carried out NDE on following
Bay 11, Tower Skirt Plates.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel FOR GREEN TAG. This QA Inspector generated an MT report(TL-6028) for this date. The members are identified as

- 1) ESD1-A67-1-147 TO 171. GREEN TAG # 9296.
- 2) ESD1-A67-2-147 TO 171. GREEN TAG # 9297.

Bay 11, West Tower, Strut Angle.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel FOR GREEN TAG. This QA Inspector generated an MT report(TL-6028) for this date. The members are identified as

- 1) WD1-A5001-LOT-1A/B.(LOT : 20, 6, 16, 23, 1, 29, 5, 22, 10).
 - 2) WD1-A5001-LOT-1A/B.(LOT : 19, 24, 21, 7, 30, 2, 32, 3, 12).
- 10% QA MT : 20, 1, 21.

GREEN TAG # 9298.

Bay 11, West Tower, Strut.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as WD1-A6003-8. GREEN TAG # 9299.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
